

Part 1 GENERAL

1.1 SECTION INCLUDES

- A. The basis of design is **Colorgalv® Thermoset 10** - Hot-dip galvanizing, factory-applied polyamide epoxy powder prime coat and fluoropolymer urethane powder topcoat for iron and steel fabrications. This system meets or exceeds the performance criteria for the AMMA 2003, AMMA 2004 and AMMA 2005 specifications.

1.2 RELATED SECTION

- A. Examine Contract Documents for requirements that affect Work of this Section. Other Specification Sections that directly relate to Work of this Section include, but are not limited to:
 - 1. Section 033000 - Cast-In-Place Concrete.
 - 2. Section 042000 - Unit Masonry.
 - 3. Section 051200 - Structural Steel Framing.
 - 4. Section 053000 - Metal Decking.
 - 5. Section 055000 - Metal Fabrications.
 - 6. Section 055100 - Metal Stairs.
 - 7. Section 055200 - Metal Railings.
 - 8. Section 057000 - Decorative Metal.
 - 9. Section 077100 - Roof Specialties.
 - 10. Section 107000 - Exterior Specialties.
 - 11. Section 107500 – Flagpoles.
 - 12. Section 129300 - Site Furnishings.
 - 13. Section 323000 - Site Improvements.
 - 14. Section 323100 - Fences and Gates.

1.3 SUBMITTALS

- A. **Product Literature for Factory-Applied Metal Coatings:** Submit galvanizer's product data sheets for coatings specified in this Section including physical performance test data.
- B. **Certificate of Compliance for Items Coated by Galvanizer:** Submit notarized Certificate of Compliance, signed by the galvanizer, indicating compliance with requirements of specifications.
- C. **Substitutions:** Substitutions must be submitted with performance criteria that meet or exceed the requirements of this specification.
- D. **Certification from the American Galvanizers Association** that Galvanizer has a certified Master Galvanizer on staff.
- E. **Certificate of Compliance for Shop Application:** The galvanizer/applicator shall be SSPC-QP3 certified.

4. QUALITY ASSURANCE

- A. **Galvanizer's Qualifications:** Galvanizer must have a minimum of ten years of experience in hot-dip galvanizing using the dry kettle process and the application of

the coatings required in this specification. The coating application must be performed in the same facility as the galvanizing.

- B. **Coordination between Fabricator and Galvanizer:** The galvanizer shall review fabricator's shop drawings for suitability of materials for galvanizing and coatings and will notify the fabricator of any required modifications.
- C. **Coating Applicator:** For the purpose of establishing a standard of quality, appearance and performance of the finished product, the finish provide by the coating applicator must be equal to or better than the finish provided by Duncan Galvanizing.

PART 2 PRODUCTS

1. SECTION INCLUDES

- A. **Hot-Dip Galvanizing:** For steel exposed to the elements, weather or corrosive environments and other steel indicated to be galvanized, provide coating for iron and steel fabrications applied by the hot-dip process. Galvanizing bath shall contain special high-grade zinc.
 - a. Basis of design: **Duragalv®**
 - b. Comply with ASTM A 123 for fabricated products and ASTM A 153 for hardware.
 - c. If required, plug vent holes after galvanizing and grind smooth.
 - d. Galvanized surface shall be prepared per SSPC SP2 or SP3 to provide a smooth surface removing all runs, drips or sags.
 - e. Galvanizing shall exhibit a rugosity (smoothness) of 16-25 microns or less when measured by a profilometer. This pertains to those elements that are less than 24 pounds per running foot.
 - f. Galvanized surfaces, that are to receive coatings, must be blasted per SSPC SP 16. The use of iron, steel shot, and aluminum oxide grit as a blast medium, and power wire brushes are not permitted.
- B. **Primer:** Provide factory-applied polyamide powder epoxy prime coat over metal that has been sandblasted per SSPC SP16.
 - 1. Basis of design: **Duncan® Thermoset.**
 - 2. Primer shall be a polyamide epoxy powder primer with 0 VOC.
 - 3. Apply primer within 12 hours after blasting at the same plant in a controlled environment meeting applicable environmental conditions and as recommended by the primer coating manufacturer. Cure schedule shall be as recommended by the manufacturer.
 - 4. Primer shall be applied at 1.8-3 mils DFT and certified OTC/VOC compliant and conform to EPA and local requirements.
 - 5. Primer shall meet or exceed the following performance criteria as stipulated by the coating manufacturer:
 - a. Cure Schedule: 10 min. at 400°F
 - b. Specific Gravity: 1.58 +/- .05 1.4-1.7 +/- .05
 - c. Coverage at 1.0 Mil 121.7 sq. ft./ lb.

- d. 60° Gloss: 55-65 (ASTM D-523)
- e. Adhesion: 5B (ASTM D-3359)
- f. Flexibility: Pass 1/8 " Mandrel Bend (ASTM D-522)
- g. Pencil Hardness: 2H-3H (ASTM D-3363)
- h. Impact Resistance: 80 in-lbs direct (ASTM D-2794) 80 in-lb reverse
- i. Typical Environmental Properties: On Bonderite 1000 Panels
- j. Salt Fog 1000 hours (ASTM B-117)
- k. Salt Fog (top-coated)* 5000+ hours (ASTM B-117)
- l. Humidity 1000 hours PASSED

B. Topcoat: Provide fluoropolymer powder topcoat. Provide coating matching approved samples. Factory-applied metal coatings shall be applied in a facility acceptable to the coating manufacturer. Full cure of the coatings shall be verified by the coating manufacturer's recommended test methods.

1. Coatings must meet or exceed the criteria for the following categories as stipulated by the coating manufacturer. All testing must be on lab prepared panels.
 - a. Adhesion: ASTM D 3359, no loss.
 - b. Hardness: ASTM D 3363 (pencil), H min.
 - c. Falling Sand ASTM D 968 40L/mil.
 - d. Salt Fog Resistance: ASTM B 117, passes 4000 hrs.
 - e. Humidity: ASTM D 2247, 4000 hours, few #8 blisters.
 - f. Impact Resistance (3mm): ASTM D 2794, no loss.
 - g. Color Retention: ASTM D 2244, 10 year less than or equal to 5 delta E.
 - h. Chalk Resistance: ASTM D 4214, #8 rating.
 - i. Gloss Retention: ASTM D 523, greater than or equal to 50 percent retention.
 - j. Erosion Resistance: ASTM B 244, less than 10 percent film loss.
 - k. Compliance: AAMA 2605.

C. Warranty:

1. Warranty: Provide galvanizer's standard warranty that materials will be free from 10 percent or more visible rust for 20 years.
2. Warranty for the finish gloss and color shall be 10 years in accordance with the following performance specifications.
 1. **Fade:** Loss of gloss shall not exceed 35 units of gloss which shall be measured in accordance with ASTM D 523-89 with 60 degree geometry.
 2. **Color Shift:** Shall not exceed 15 Delta E CIE LAB units for whites and light colors. Dark colors shall not exceed 25 Delta E CIE Lab units as measured by ASTM D 2244. (Yellows, Oranges and Reds are excluded.)

PART 3 EXECUTION

3.1 APPLICATION OF FACTORY APPLIED METAL COATINGS

- A. **Galvanizing Application:** Galvanize materials in accordance with specified standards and this specification. The dry kettle process shall be used to eliminate any flux inclusions on the surface of the galvanized material. The use of the wet kettle process is prohibited.
- B. **Prior to Galvanizing:** The steel shall be immersed in a flux solution (zinc ammonium chloride). The flux tank must be 12 to 14 Baumé density and contain less than 0.4 percent iron.
 - 1. To provide the galvanized surface required, the following procedures shall be implemented:
 - a. A monitoring recorder shall be utilized and inspected regularly to observe any variances in the galvanizing bath temperature.
 - b. The pickling tanks shall contain hydrochloric acid with an iron content less than 12 percent and zinc content less than 3 percent. Titrations shall be taken weekly at a minimum.
 - c. All chemicals and zinc shall be tested at least once a week to determine compliance with ASTM standards. All testing shall be done using atomic absorption spectrometry or x-ray fluorescence (XRF) equipment at a lab in the galvanizing facility.
- C. **Coatings shall be applied under the following conditions:**
 - 1. Surface of the substrate shall be dry and free from dust, dirt, oil, grease or other contaminants. Coating and cure facility shall be maintained free of airborne dust and dirt until coatings are completely cured.
 - 2. All coatings must be applied in a controlled environment under the conditions specified by the coating manufacturer. All coatings must be mixed and applied according to the coating manufacturer's specifications.

3.2 INSTALLATION

- A. **Installation:** Comply with fabricator's and galvanizer's requirements for installation of materials and fabrications, including use of nylon slings or padded cables for handling factory-coated materials.
- B. **Touch-Up and Repair:** For damaged and field-welded metal coated surfaces, clean welds, bolted connections and abraded areas the following procedures must be used.
 - 1. For galvanized surfaces, apply organic zinc repair paint complying with requirements of ASTM A 780, modified to 95 percent zinc in dry film. Galvanizing repair paint shall have 95 percent zinc by weight. Basis of design is ZIRP by Duncan Galvanizing. Thickness of applied galvanizing repair paint shall be not less than coating thickness required by ASTM A 123 or A 153 as applicable.
 - 2. For factory-applied finish coatings, field-touch-up shall be performed by qualified applicators with experience in the application of high-performance industrial coatings. All coating manufacturer's requirements for mixing, application and environmental conditions must be followed. Touch-up shall be performed so that the repair is not visible from a distance of 6 feet. A touch-up repair kit and repair procedures shall be provided to the Owner for each type of factory-applied finish upon request.

END OF SECTION